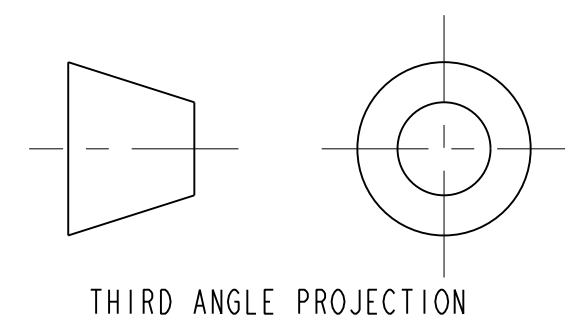
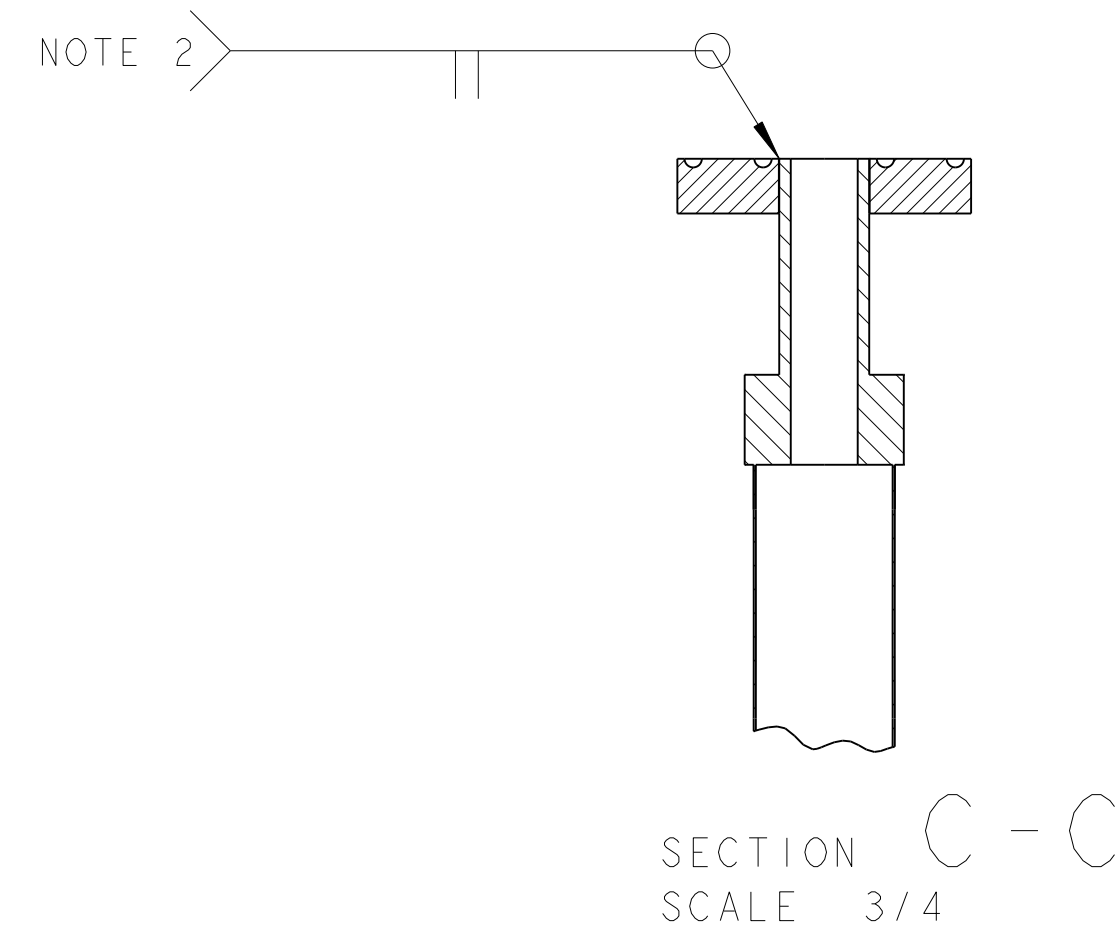
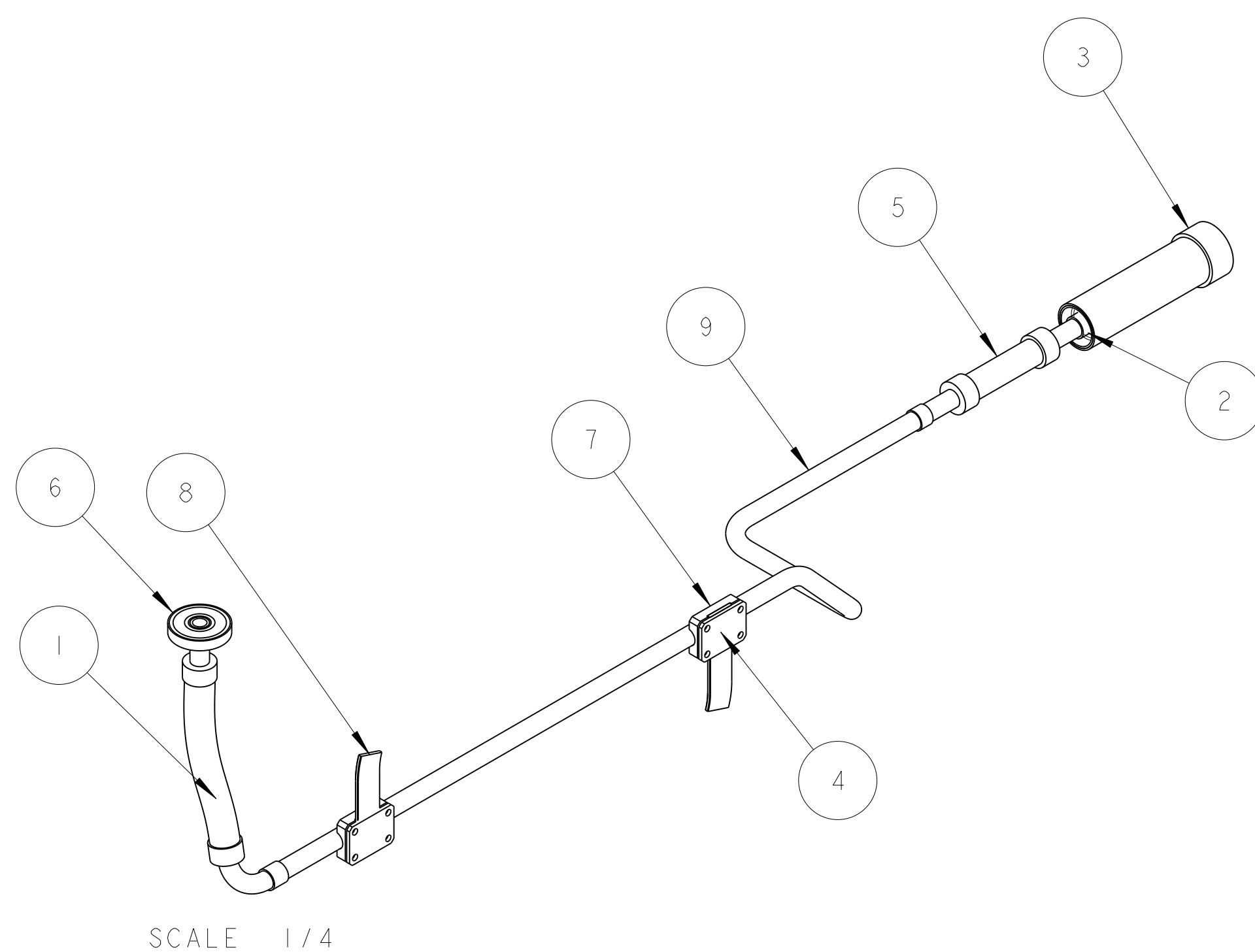
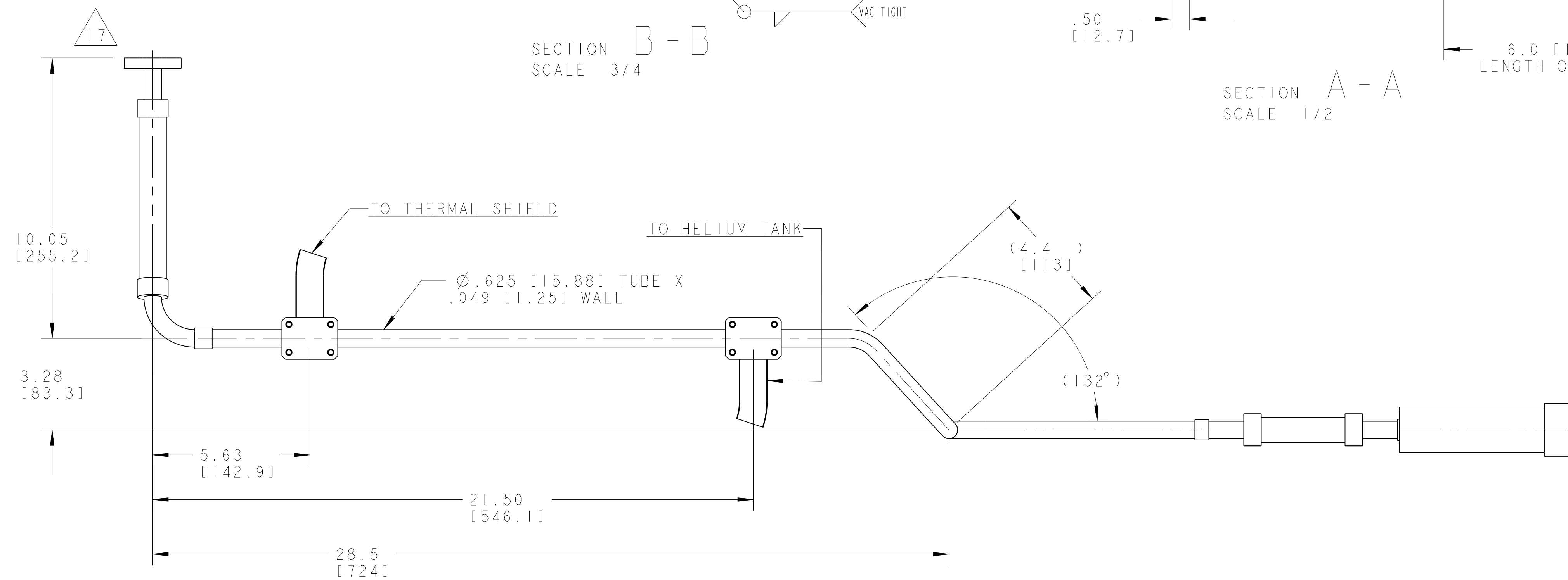
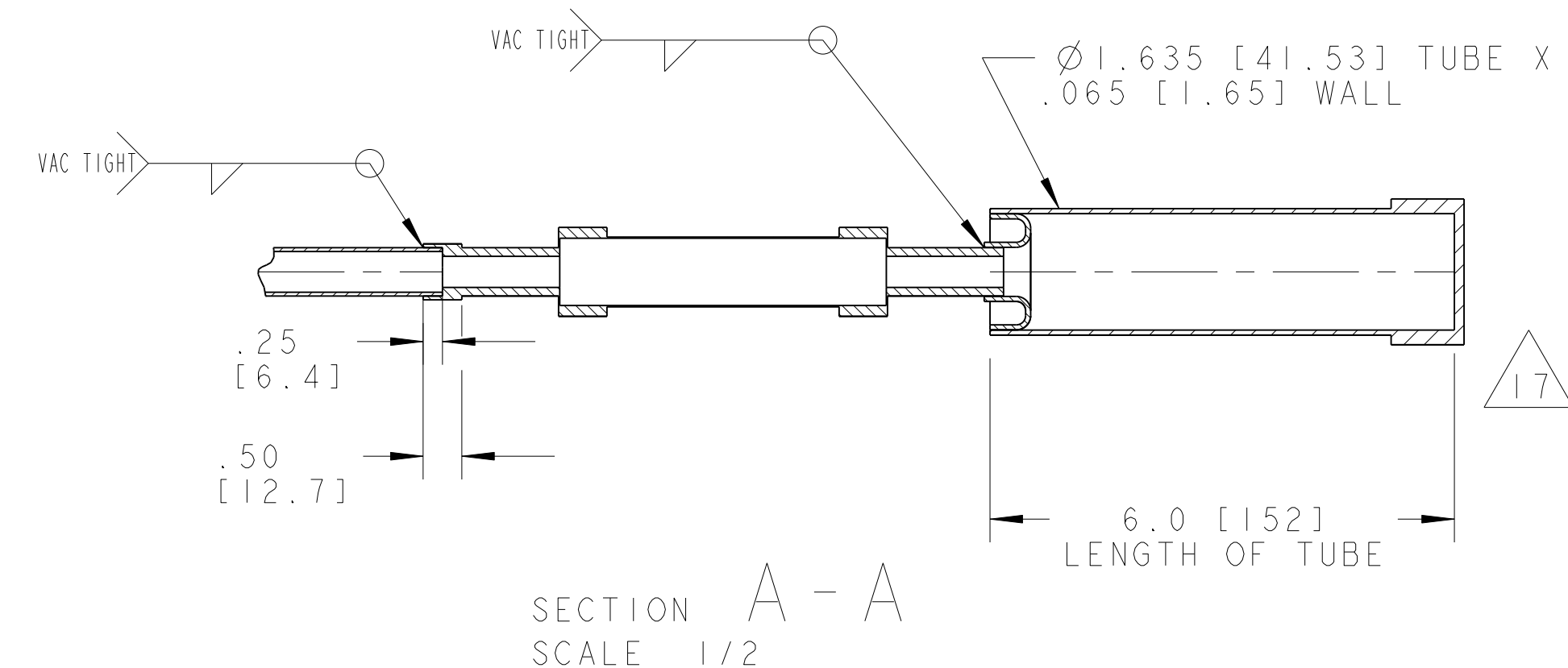
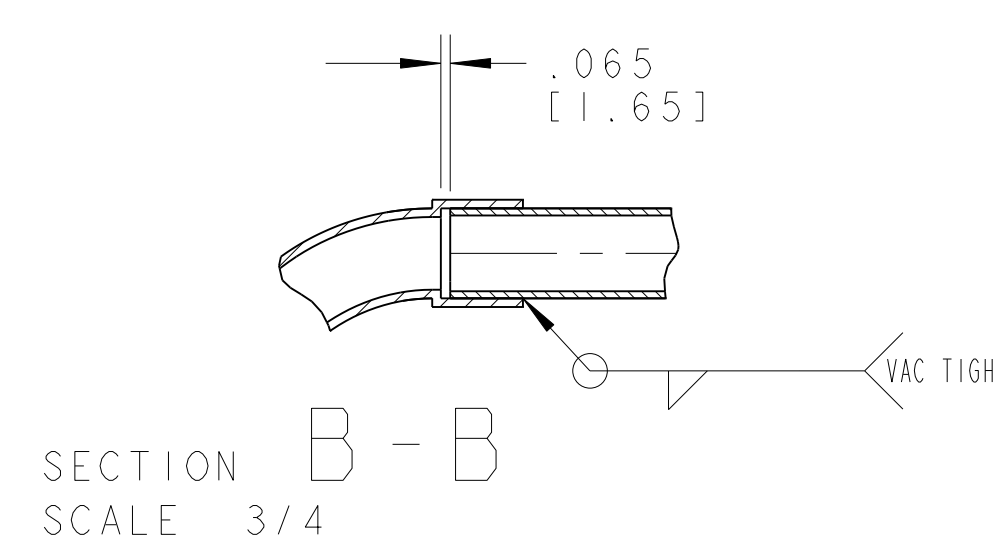
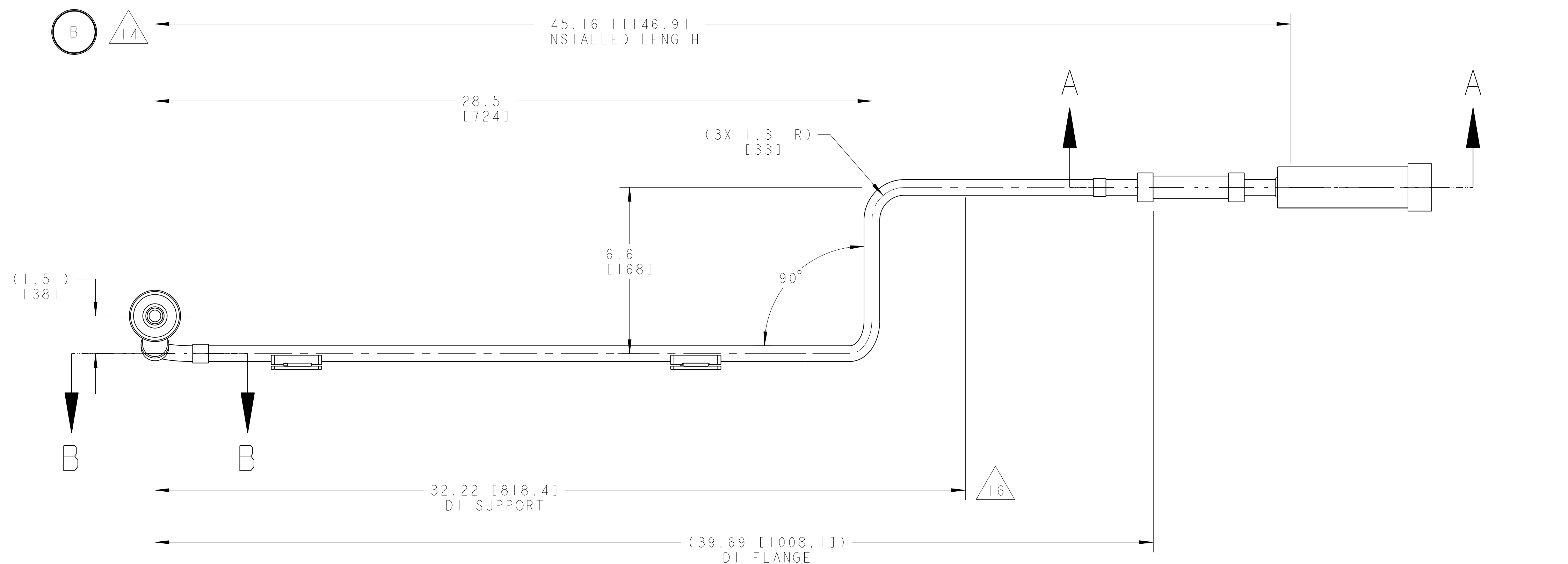
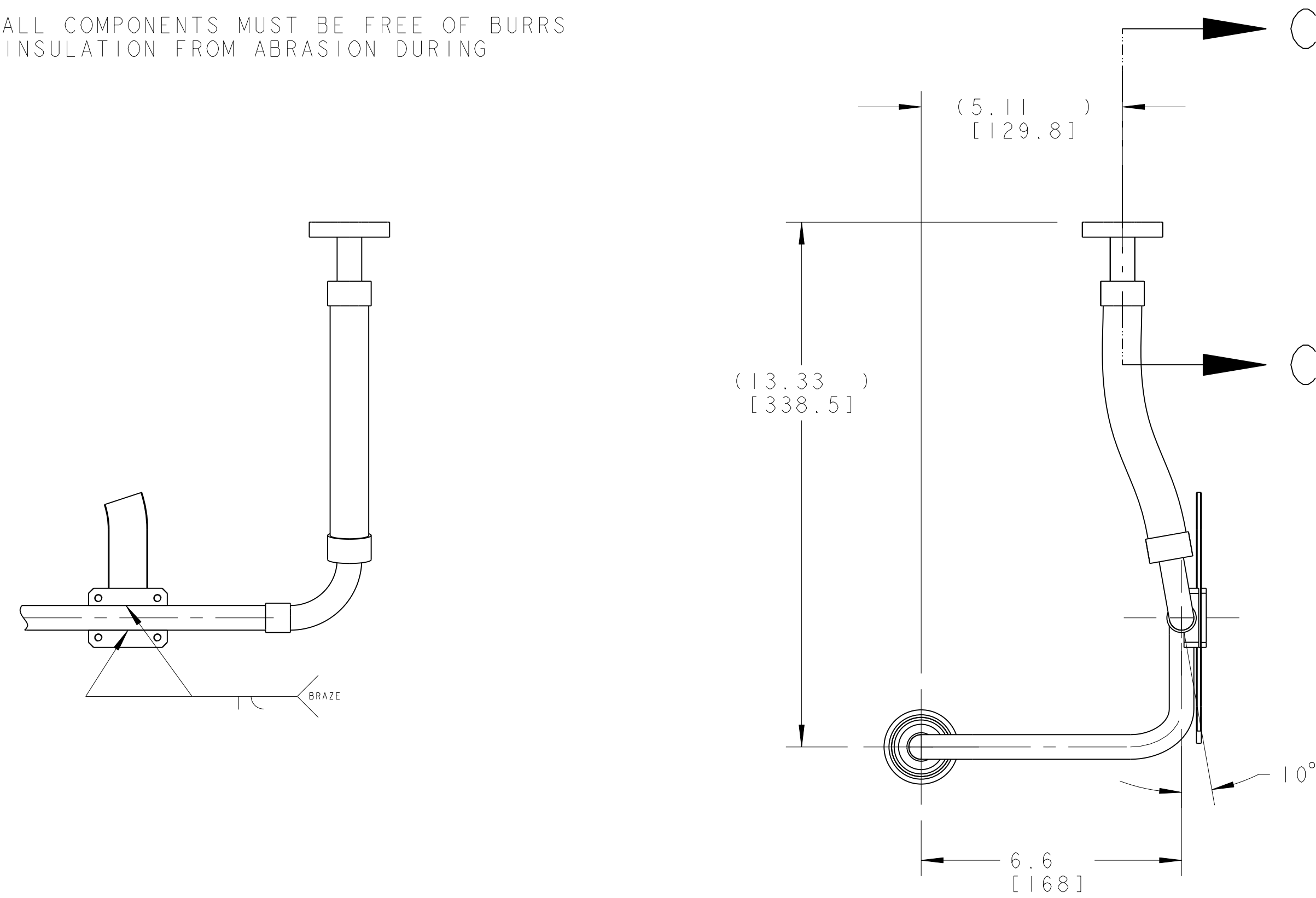


1. THIS IS A CRYGENIC VACUUM COMPONENT.
2. WELDING PROCEDURE: PER VENDOR SPECIFICATION WITH LBNL APPROVAL.
3. CLEANING PROCEDURE : PER VENDOR SPECIFICATION WITH LBNL APPROVAL.
4. PACKAGING AND STORAGE PROCEDURE OF THE COMPONENTS: PER VENDOR SPECIFICATION WITH LBNL APPROVAL.
5. DIMENSIONS AND TOLERANCING PER ANSI Y14.5M-1982. UNITS ARE IN INCHES [mm] UNLESS OTHERWISE SPECIFIED.
6. USE OF SULFUR OR SILICONE BEARING OILS, LUBRICANTS, OR COOLANTS ARE STRICTLY PROHIBITED.
7. USE OF RESIN OR RUBBER BONDED ABRASIVES UNDER POWER IS STRICTLY PROHIBITED. USE VITREOUS BONDED ABRASIVES ONLY.
8. VENDOR SUGGESTED CHANGES TO WELD PREPS; SUBJECT TO LBNL APPROVAL.
9. FITTINGS MAY BE USED IN PLACE OF BENDS; SUBJECT TO LBNL APPROVAL.
10. VENDOR SUGGESTED CHANGES TO TOLERANCES TO FACILITATE FABRICATION OR ASSEMBLY; SUBJECT TO LBNL APPROVAL.
11. REMOVE ALL THE BURRS AND REAM THE ENDS FOR CIRCULARITY AND CLEAN ENDS.
12. TUBE END SURFACE MUST BE PERPENDICULAR TO THE TUBE AXIS WITHIN $\pm .010$.
13. PERFORM ACCEPTANCE TESTS PER LBNL SPECIFICATION M989. **B**
14. A MARK DESIGNATING THE INSTALLED LENGTH WILL BE UTILIZED DURING FINAL INSTALLATION OF THE FEEDBOX ASSEMBLY. MARK, SCRIBE OR ETCH THIS LOCATION IN A PERMANENT MANNER, SUBJECT TO LBNL APPROVAL, TO AN ACCURACY OF ± 0.063 ".
15. PROVIDE A MINIMUM LENGTH OF 4.0" OF STRAIGHT, SMOOTH PIPE ON THE INDICATED SIDE OF THE INSTALLED LENGTH MARK FOR PIPE WELDING DURING FINAL INSTALLATION OF THE FEEDBOX ASSEMBLY.
16. PIPE MUST BE STRAIGHT AND SMOOTH (NO BUMPS) FOR 1.5" ON EITHER SIDE OF THE CENTER-PLANE OF THE SUPPORT.
17. CAP END OF PIPE TO FACILITATE ACCEPTANCE TESTS. **B**
18. ALL CAPPED PIPE EXTENSIONS WILL BE CUR DURING FINAL INSTALLATION OF THE FEEDBOX.
19. THE INTERIOR OF ALL COMPONENTS MUST BE FREE OF BURRS TO PREVENT WIRE INSULATION FROM ABRASION DURING THERMAL CYCLING.



B	ARH	SPV	01/09/03		REVISED DRAWING NOTES 13, 16 & 17, COSMETIC CHANGES TO DRAWING, DWG VIEW NOTE 14 WAS NOTE 19, UPDATED ROW DESCRIPTION FOR ITEMS 1, 3, 5 & 9, MINOR DRAWING DIMENSIONAL CHANGES
A	ARR	DPO	9-17-02		INITIAL RELEASE
REV	DWG	CHK	ZONE	DATE	CHANGES

B

9

-

1

TUBE, PER ASTM A269

SS 304L

8

-

2

COPPER BRAD, 1" x 1/8"

C

25M873

2

CLAMP BASE PLATE, 5/8" TUBE

COPPER, OFHC, C101

251641

1

INSERT, 5/8" TUBE WELD FLANGE

SS 304L

5

1

BRAIDED FLEX HOSE, 1/2" ID 3" x 3" LL

SS 300 SERIES

25M813

2

CLAMP COVER 1"

OFHC, C101

D

-

1

TUBE, PER ASTM A269

SS 304L

2

251644

1

BELLOWS FLANGE, ROLLED

SS 304L

E

-

1

BRAIDED FLEX HOSE, 1/2" ID, 6" LL

SS 300 SERIES

ITEM

PART NO

REQD

DESCRIPTION

UNLESS OTHERWISE SPECIFIED

SHOP ORDERS

SERIAL

DATE

TOLERANCES:

X.X ± 0.1

FRACTIONAL

1/16"

X.XX ± 0.03

ANGLES ± 1.00°

X.XXX ± 0.010

FINISH

12-50

DO NOT SCALE PRINT

THREADS ARE CLASS 2

CHAMFER ENDS OF ALL SCREW THREADS 30°

CUT THREADS, 1.5 THREAD RELAY ON UNCHANGED THREADS

HOLE SIZES: VARY BY 0.001 ON UNCHANGED HOLES

HOLEY BORES: WELD SPATTER & LOOSE SCALE

IN ACCORDANCE WITH ASME Y14.5-M-24-1

SUBVISE

PROJECT

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